

Work Order ID 127150

December-09-14 11:19:17 AM

127150

Page 1

Item ID: D4653-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Collar
 Start Date: 16/12/2014 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 23/12/2014 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4653	REV A								
100	Cut blanks as per folio	0.00							DAS 40 9-89
100						20	0		14/12/15
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK AT 3.600"								
105		0.00							DAS 40 9-89
105	Hardinge CNC LATHE SMALL					20	0		14-12-16 14/12/15
Doosan	Memo	0.00							
Doosan Lathe	Machine as per folio FB115								
	FOLIO REV: <u>NA</u>								
	DWG REV: <u>A</u>								
	Deburr								

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N900040100

Setup Start *NS1*

Stop *NS2*

20

20

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS SL
40
9-89 14-12-16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

70 86

14.12.17

121

Chemical Conversion Coat per QSI005 4.1

0.00

121

HandFinish

Memo

0.00

Hand Finishing

20 14-12-19 DGE

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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123	QC7-Inspect Chemical Conversion Coat	0.00				(20)			DAS 38 9-09
123									
QC	Memo	0.00							
Quality Control									

DEC 19 2014

130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.00							DAS 06 9-09
Packaging									

20

DEC 22 2014

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/1/50

4-12-22

Picklist Print

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Work Order ID: 127150

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Parent Item: D4653-3

D4653-3

Parent Item Name: Collar

Start Date: 16/12/2014

Required Date: 23/12/2014

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500		Purchased	No				f	17.0000		5	DAS 40 9-89	DAS 37 9-89	
M6061T6R3 500									**			14.12.10	
6061 RD bar 3.50													

Location

Loc Qty

Loc Code

MAT013

17

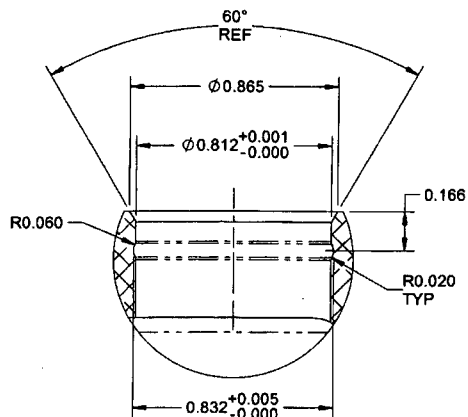
→ m130089

12.5

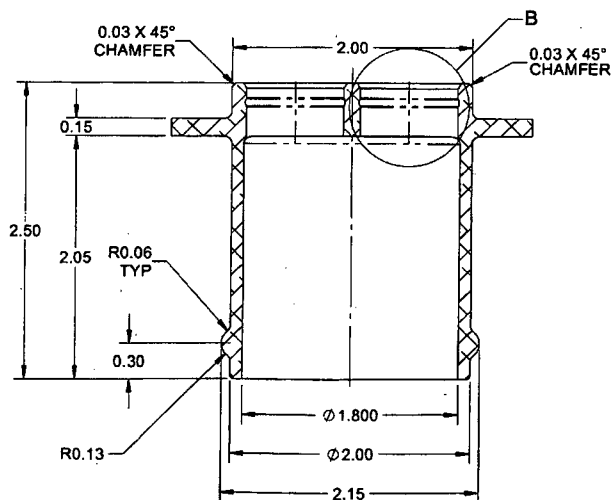
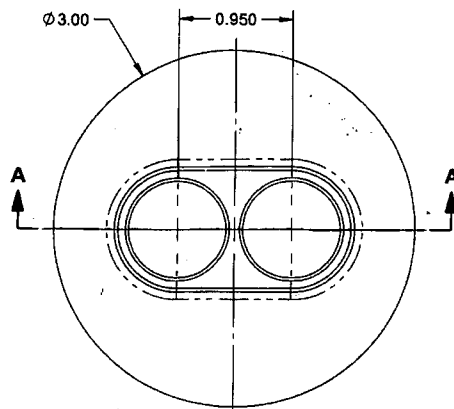
m130527

4.5

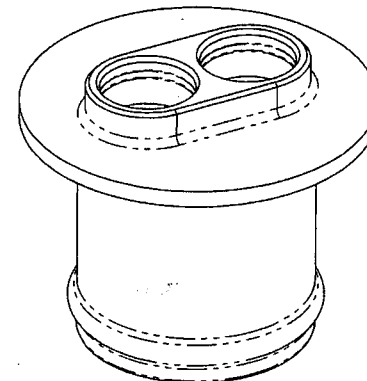
1.5
4.5 pc



SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



D4653-3 COLLAR

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2012-11-05
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4653	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	